

Work Order ID 73312

Wednesday, August 31, 2011 10:49:24 AM



Page 1

Item ID:	D3536-23	Accept		Setup	Start	
Revision ID:						
Item Name:	Gasket				Stop	
Start Date:	9/1/2011	Start Qty:	16.00			
Required Date:	9/15/2011	Req'd Qty:	16.00			
Reference:						

Approvals:	Process Plan:	<i>MF</i>	Date:	11-09-11	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3536	Rev A								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3536 <input type="checkbox"/> Dwg Rev: <u>A</u> <input type="checkbox"/> Prog Rev: <u>A</u> <input type="checkbox"/> 2- Deburr if necessary								

11-9-29



110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

11-9-29

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

11-9-29



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73312

Wednesday, August 31, 2011 10:49:24 AM



Page 2

Item ID: D3536-23

Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 9/1/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 16.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location FP-2

0.00



Packaging

Memo

0.00

Packaging

X26 @ all 11/09/29
COUNT

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/3 MF

MF
11-09-29

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, August 31, 2011 10:49:21 AM

Page 1

Work Order ID: 73312



Parent Item: D3536-23



Parent Item Name: Gasket


Start Date: 9/1/2011

Required Date: 9/15/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063  NEOPRENE SHEET 0.063		Purchased	No			100	sf	583.5500	1.3365	23.76	35. B11-9-29		



Location

Loc Qty

Loc Code

MAT052

583.55

117295

55.68

118026

127.87

118663

400

118663

26

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	73312
Description: Gasket		Part Number:	D3536-23
Inspection Dwg: D3536	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
52.85	+/-0.030	52.85	2		T B01	
48.20	+/-0.030	48.20	2		T	
44.70	+/-0.030	44.70	2		T	
39.31	+/-0.030	39.31	2		T	
33.92	+/-0.030	33.92	2		T	
28.53	+/-0.030	28.53	2		T	
23.14	+/-0.030	23.14	2		T	
17.75	+/-0.030	17.75	2		T	
14.25	+/-0.030	14.25	2		T	
9.50	+/-0.030	9.50	2		T	
4.75	+/-0.030	4.75	2		T	
8.00	+/-0.030	8.00	2		T	
16.00	+/-0.030	16.00	2		T	
24.00	+/-0.030	24.00	2		T	
32.00	+/-0.030	32.00	2		T	
39.00	+/-0.030	39.00	2		T	
48.00	+/-0.030	48.00	2		T	
0.30	+/-0.030	0.310	2		V B02	
0.30	+/-0.030	0.308	2		V	
1.89	+/-0.030	1.888	2		V	
Ø0.19	+0.005/-0.001	0.191	2		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 11-9-29	Date: 11/09/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

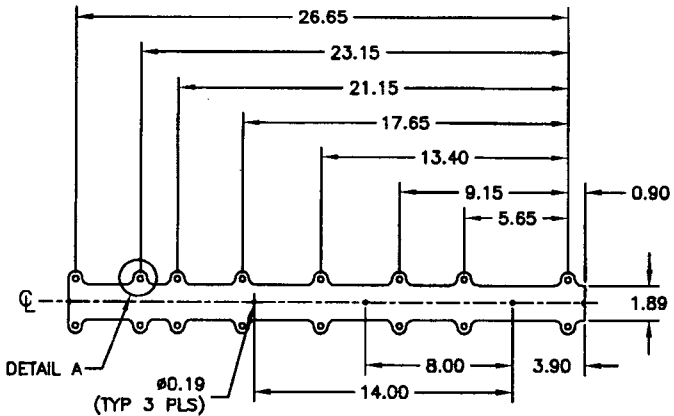
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

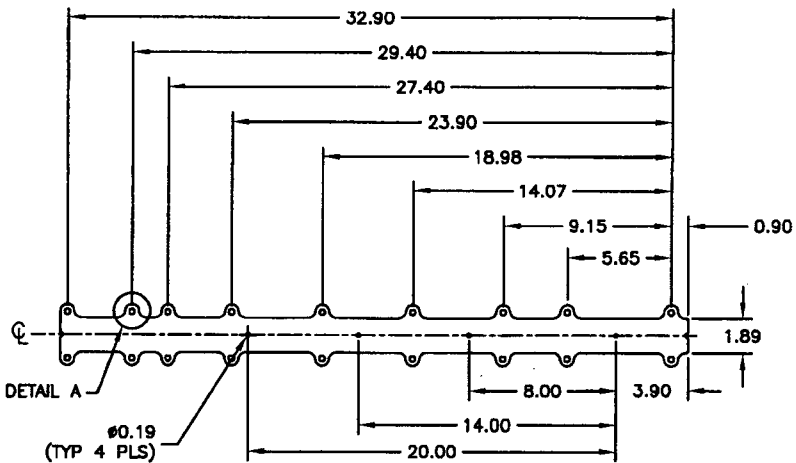
DART

09.02.12-11

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.	
PORT HADLOCK, WA					
CHECKED	PH	APPROVED	[Signature]	DRAWING NO.	D3536
				REV. A	SHEET 1 OF 6
DATE	06.10.25		TITLE		SCALE
			GASKET		1:10
A		06.10.25	NEW ISSUE		



D3536-11 GASKET



D3536-13 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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73212

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector


Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

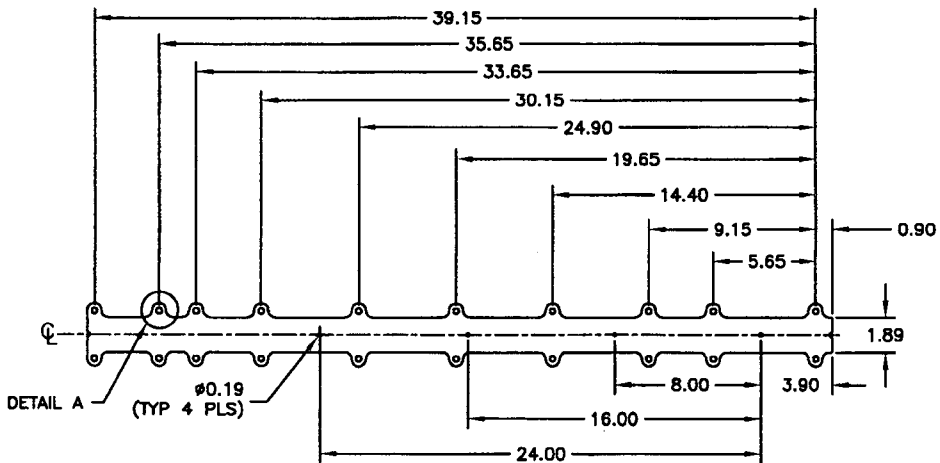
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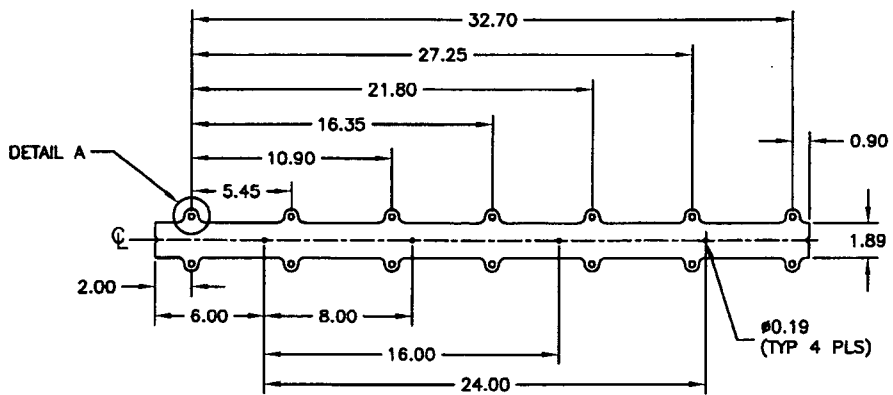
NOTE: Date & initial all entries

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED CH	APPROVED 	DRAWING NO. D3536	REV. A SHEET 2 OF 6
DATE 06.10.25	TITLE GASKET		SCALE 1:10



D35.36-15 GASKET



D35.36-21 GASKET

- ## NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

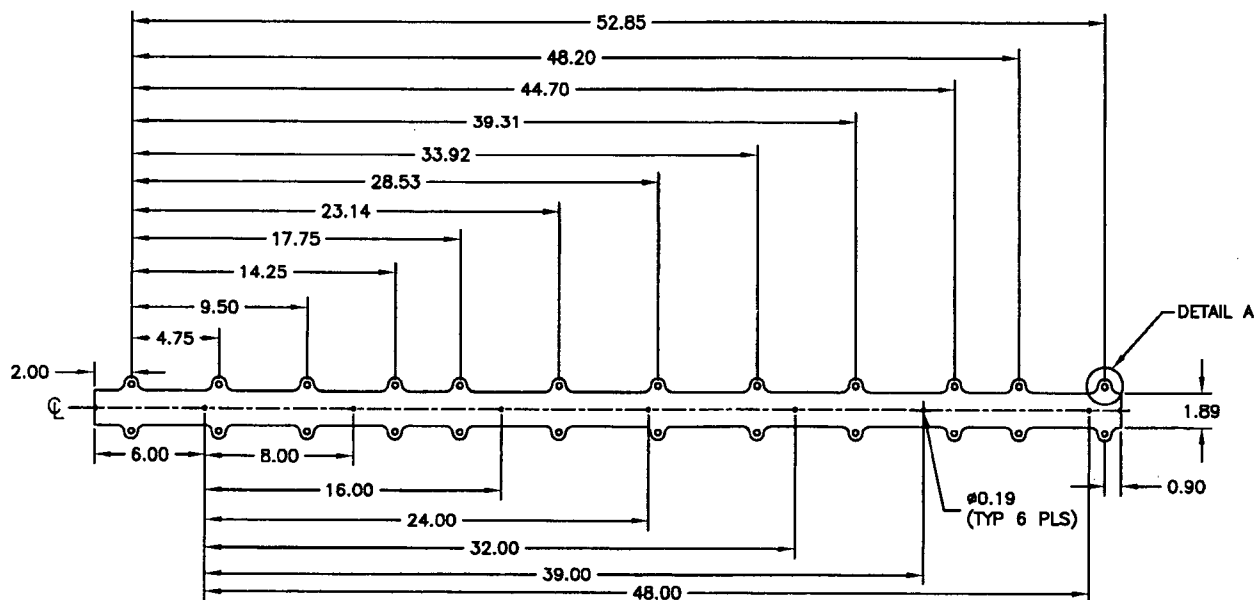
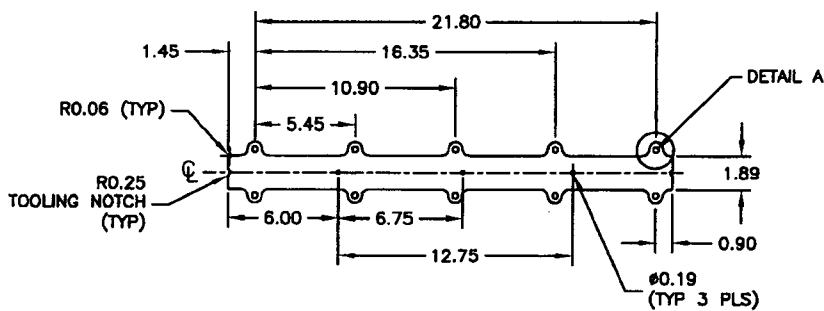
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NOTE: Date & initial all entries

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DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 3 OF 6
				SCALE 1:10

**D3536-23 GASKET****D3536-25 GASKET****NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

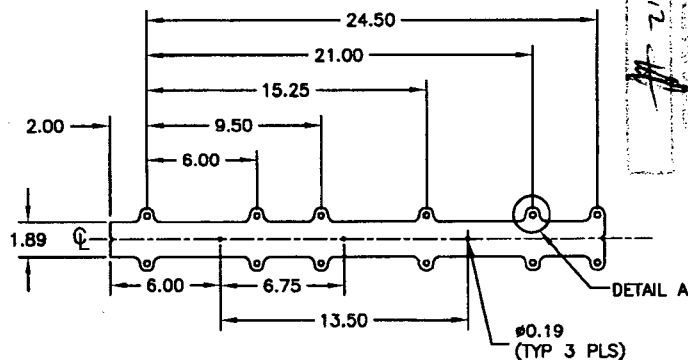
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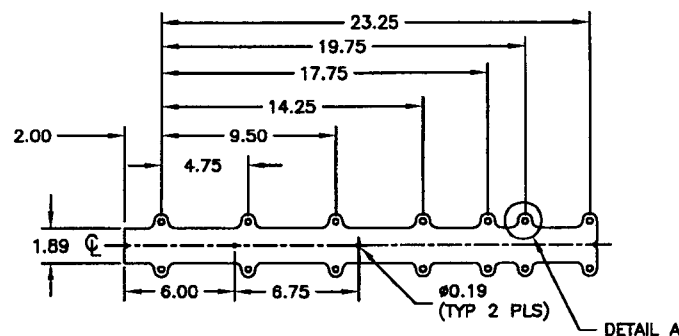
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
		GASKET		SHEET 4 OF 6
				SCALE 1:10

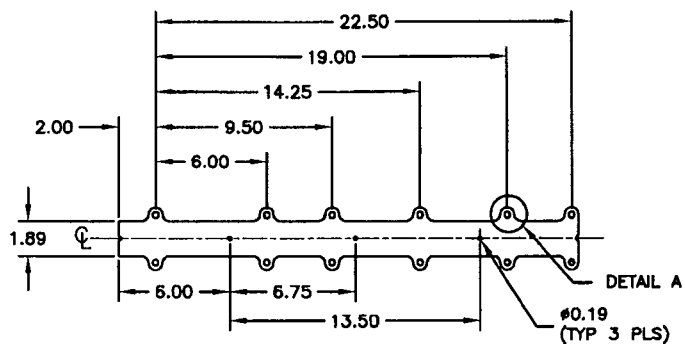
07.02.12



D3536-33 GASKET



D3536-35 GASKET



D3536-31 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
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#73312

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

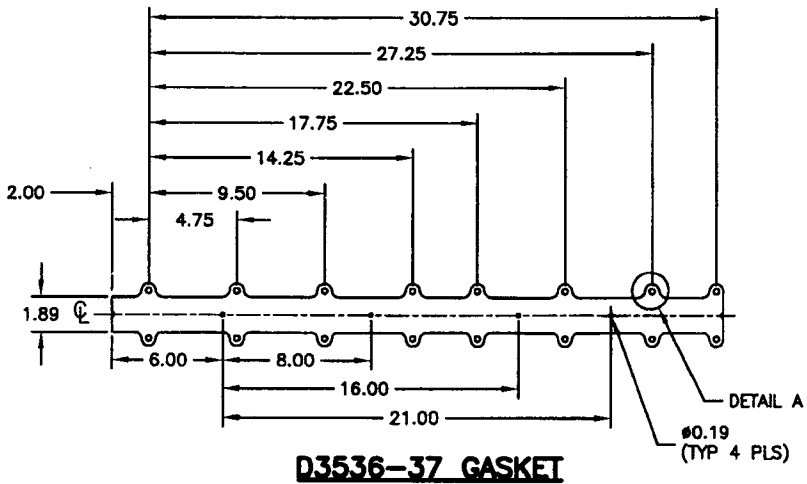
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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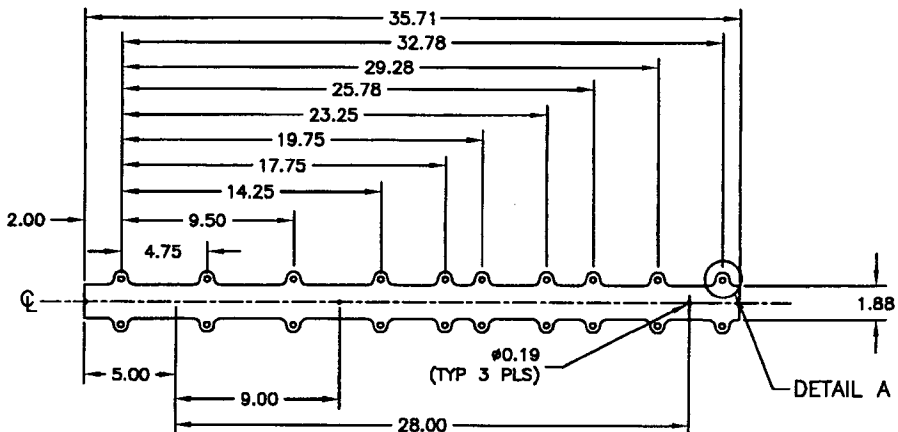
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CHECKED PH	APPROVED 	DRAWING NO. D3536	REV. A SHEET 5 OF 6
DATE 06.10.25		TITLE GASKET	SCALE 1:10



D3536-37 GASKET

73312



D3536-39 GASKET

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60
DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT
PERMANENT INK MARKER
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

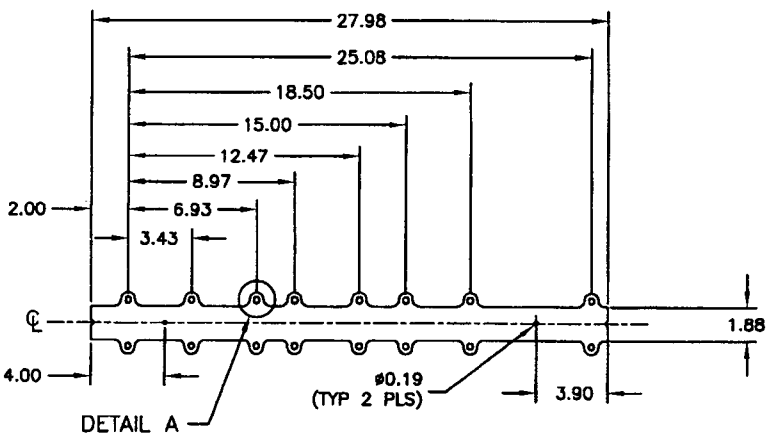
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DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED <i>[Signature]</i>	DRAWING NO. D3536	REV. A
DATE 06.10.25	TITLE GASKET	SHEET 6 OF 6	SCALE 1:10

070202 *[Signature]*

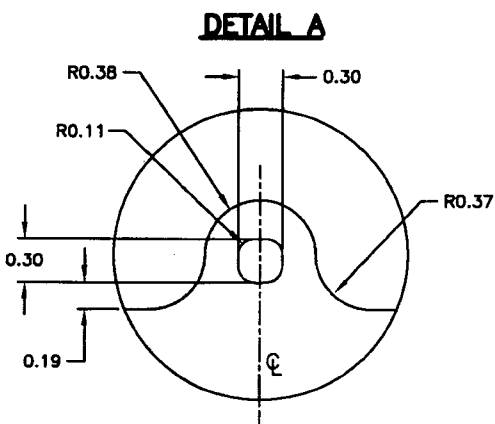


D3536-41 GASKET

21446 #

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
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